

**Work Order ID 59349**

Wednesday, June 02, 2010 10:32:18 AM



Page 1

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 6/2/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-6-02

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3910	B

100



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.450" LONG

0.00

M. A 10/06/1024Ø

110



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: BDWG REV: B

0.00

M. A 10/06/1024Ø

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3910-1

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Start Date: 6/2/2010 Start Qty: 24.00

Accept



Setup Start



Stop



Required Date: 6/9/2010 Req'd Qty: 24.00



Cust Item ID:



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

130



QC8- Inspect parts - second check

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

HandFinish

Hand Finishing

0.00

0.00

0.00

0.00

H.A 10/06/10

24 Ø

MMF  
10/06/11

24 Ø

24 - BK 10-6-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 59349**

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Item ID: D3910-1

Accept



Setup

Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 6/2/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M114841

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

=) M 10/06/15

24 8

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

24 BK 10-6-15

170



Packaging

Packaging

Identify as per dwg & Stock Location SO7

0.00

16 6 15



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 59349**

Wednesday, June 02, 2010 10:32:18 AM



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Item ID: D3910-1

Accept



Setup Start



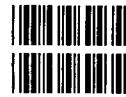
Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 6/2/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

180

Operation  
Description

QC21- Final Inspection - Work Order Release

QC

Quality Control

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

10/06/17 HJ

Memo

0.00

MF  
10-6-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date, & initial all entries

# Picklist Print

Wednesday, June 02, 2010 10:32:17 AM

Page 1

Work Order ID: 59349



Parent Item: D3910-1



Parent Item Name: Crosstube Lug

Start Date: 6/2/2010

Required Date: 6/9/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD  
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	470.5321	0.13	3.284211			

Lug Extrusion

Location	Loc Qty	Loc Code
MAT06	470.5320795	
43722	180	
45800	290.532079	

3.28424 A,A 10/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DART AEROSPACE LTD	Work Order:	59349
Description: X - TUBE LUG (350)	Part Number:	D3910-1
Inspection Dwg: D3910 Rev: B		Page 1 of 1

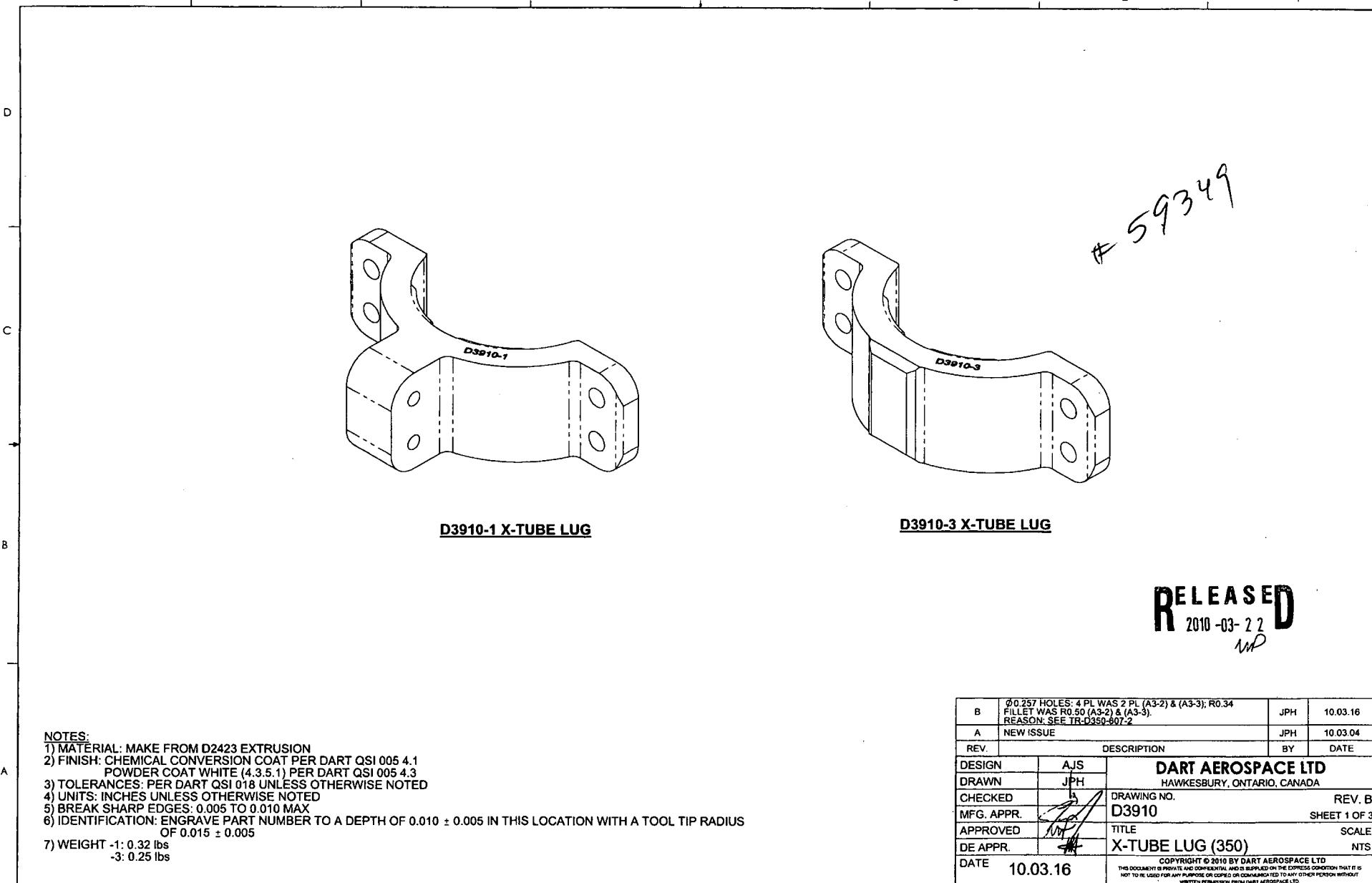
# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	J. A	Audited by:	MMF	Prototype Approval:	N/A
Date:	10/06/10	Date:	10/06/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1



B	$\varnothing 0.257$ HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-0350-607-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	BY		DATE	
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH	DRAWING NO.	D3910	REV. B
CHECKED				SHEET 1 OF 3
MFG. APPR.		TITLE	X-TUBE LUG (350)	SCALE
APPROVED		DE APPR.		NTS
DATE	10.03.16		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

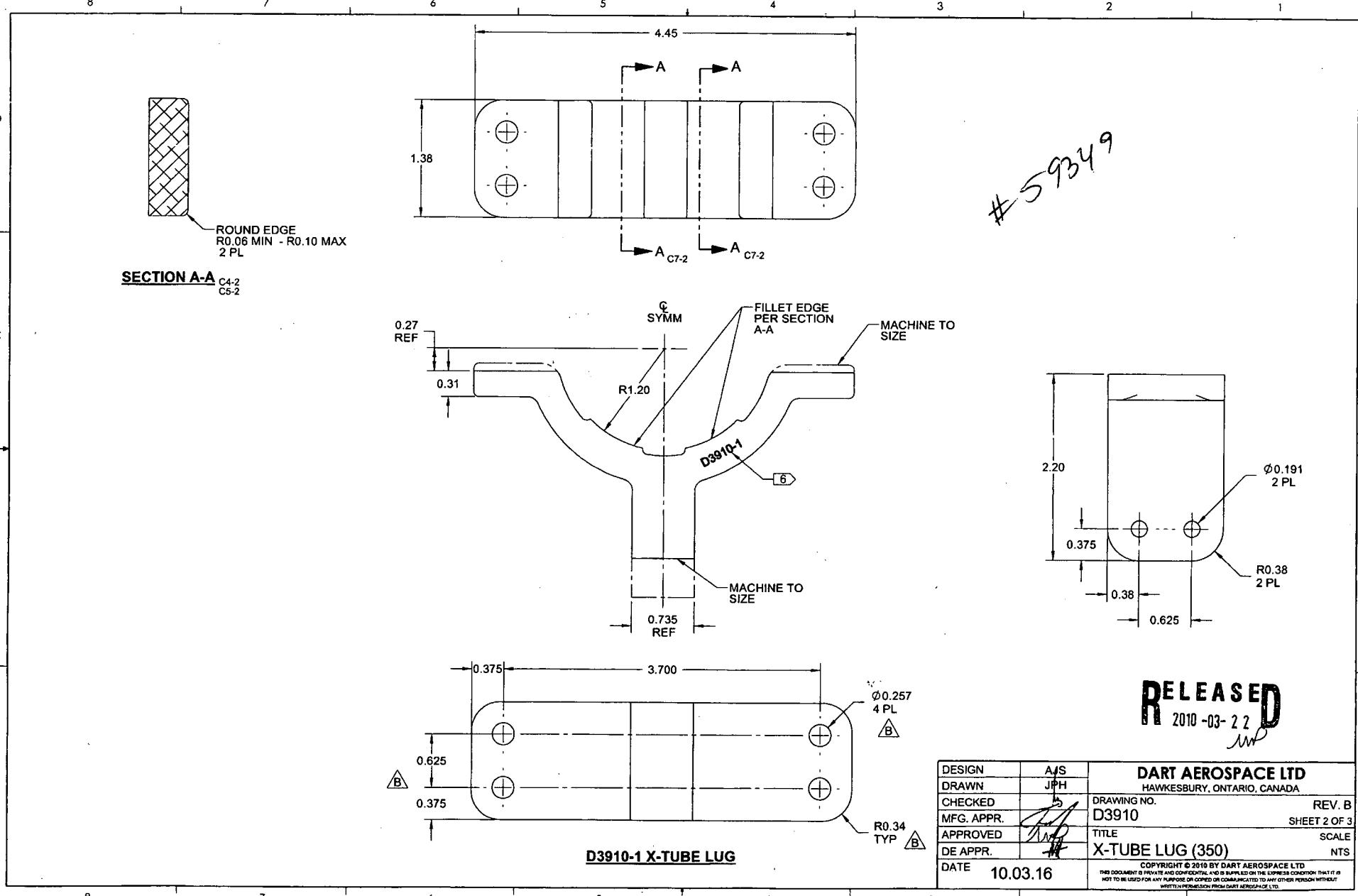
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN	A/S	DART AEROSPACE LTD
DRAWN	JPH	HAWKSBUCK, ONTARIO, CANADA
CHECKED	<i>JS</i>	DRAWING NO.
MFG. APPR.	<i>JS</i>	D3910
APPROVED	<i>MM</i>	REV. B
DE APPR.	<i>MM</i>	SHEET 2 OF 3
DATE	10.03.16	SCALE
		NTS

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RELEASED  
2010-03-22  
*MM*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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